

Date: Wednesday, 14/11/2007 1:24:20 PM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.		Drawing Name	: G10608-1	
Job Number	: 35387		Part Number	: D3637041	
Estimate Number	: 10804		Drawing Number	: RE-IDENTIFY	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 14/11/2007	S.O. No. : N/A	Drawing Revision	: N/A	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: 25/10/2007	Type : SMALL /MED FAB	Due Date	: 01/11/2007 Qty: 11 Um: Each	
Previous Run	: 35384				
Written By	:				
Checked & Approved By	:				
Comment	:				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 Comment: LARGE FABRICATION RESOURCE 1 <i>316 SS. ROD 1 B m/104721</i> <i>weld over countersinks</i> <i>surf. grind smooth</i> <i>FC 07/11/19 ⑪</i>
3.0	QC9	VISUAL WELDING INSPECTION Comment: VISUAL WELDING INSPECTION <i>⑪ 07-11-19 ⑪</i>
4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 <i>INSTALL NUTPLATE PER DRWG D3637 REV.A</i> <i>ml 07/11/20 x 11</i>
5.0	G106081	Bracket Comment: Qty: 1.0000 Each(s)/Unit Total: 11.0000 Each(s) <i>Doubler</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/11/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/11/20	4	C sink not deep enough. Bad install of rivets.	081042	took out 2 rivets and nut plate, Re-do C sink. Replace 2 rivets ms20427AD and 1 nutplate ms21059L4 m102959	07/11/20	081042	081042	081042

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
6.0	MS21059L4	Nutplate
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 11.0000 Each(s)	M102959 ✓ ml 07/11/19
7.0	MS20426AD33	Rivet
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 22.0000 Each(s)	M1563 ml 07/11/19
8.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	✓ ml 07/11/20 (XII)
9.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1	(II)
	RESTOCK AS D3637-041 USING NEW B/N	ST. 267 K 07/11/20 (II)
10.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	07/11/20 (II)

Job Completion



✓ 07.11.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

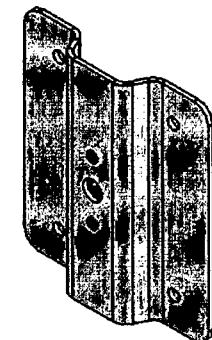
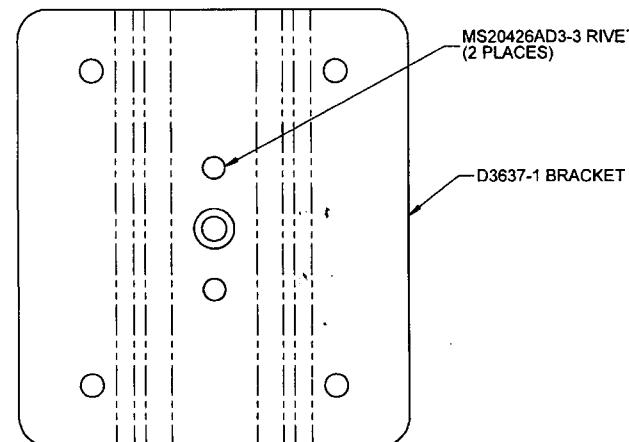
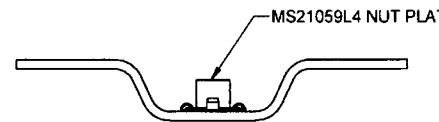
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



W/0 35387

D3637-041 BRACKET ASSEMBLY
(WAS GENEVA P/N G10602-1)

D3637-041 PARTS:

QTY	P/N	DESCRIPTION
X	D3637-041	BRACKET ASSEMBLY
1	D3637-1	BRACKET
1	MS21059L4	NUTPLATE
2	MS20426AD3-3	RIVET

D3637-041 NOTES:

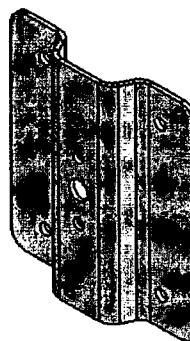
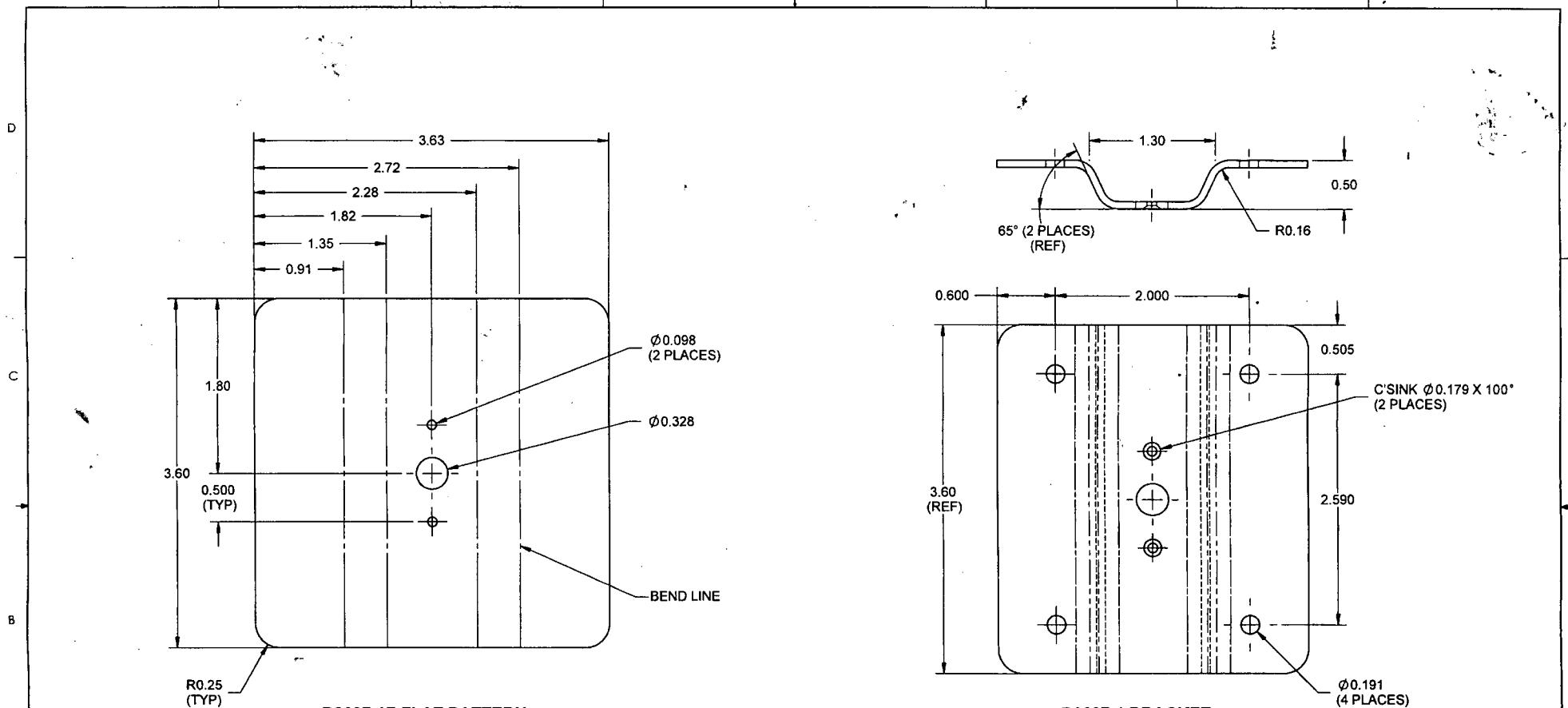
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

RELEASED
07.09.07

A	NEW ISSUE; REPLACES G10608, G10602 & G10609		LE	07.07.27
REV.	DESCRIPTION		BY	DATE
DESIGN	TS	DART AEROSPACE LTD		
DRAWN	15	HAWKESBURY, ONTARIO, CANADA		
CHECKED	90	DRAWING NO.	D3637	REV. A
MFG. APPR.	83	APPROVED	100	SHEET 1 OF 3
DE APPR.	99	DE APPR.	99	SCALE
DATE	07.07.27		BRACKET	1:1
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

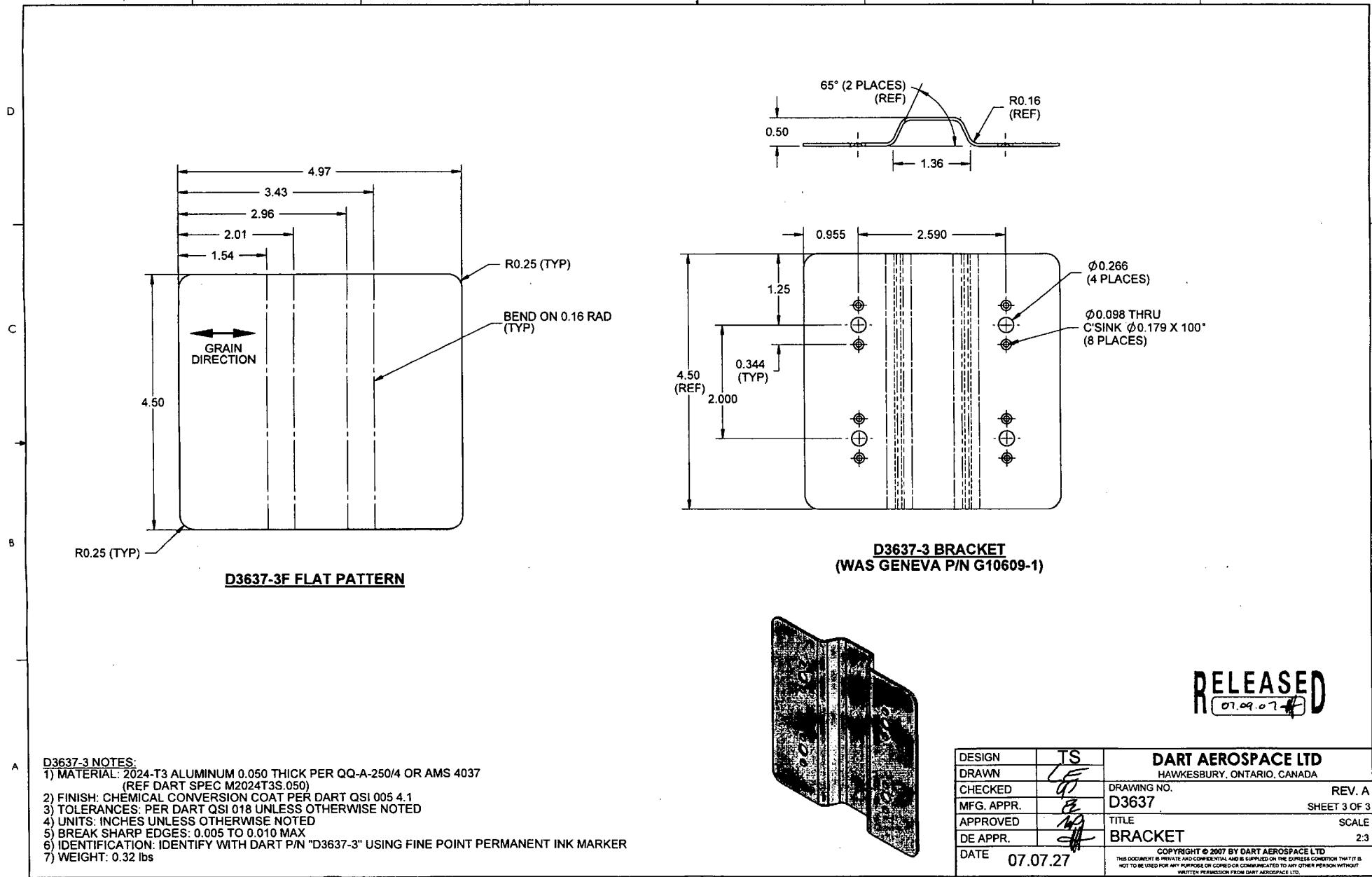


D3637-1 NOTES:
 1) MATERIAL: AISI 304/316 SS SHEET, 14 GAUGE PER MIL-S-5059
 (REF DART SPEC M304S14GA)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 0.26 lbs

DESIGN	TS	DART AEROSPACE LTD
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA
CHECKED	90	REV. A
MFG. APPR.	3	DRAWING NO. D3637 SHEET 2 OF 3
APPROVED	10	TITLE SCALE
DE APPR.	CH	BRACKET 1:1
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RELEASED
07.09.01

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

L Lacelle

From: Leanne Elsliger [leelsliger@dartaero.com]
Sent: November 5, 2007 4:20 PM
To: 'Linda Lacelle'
Subject: D3637-1

Linda – the Geneva p/n G10608-1 that we gave Dart p/n D3637-1 has two countersinks that we do not have on our part. I forgot about these until Eric D brought them to my attention (sorry). There are 11 of them. You can either scrap them or rework the parts by welding.

Leanne

Leanne Elsliger, P.Eng
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